										-11-		
. Work Orde Wednesday, Sep		06966 013 2:00:39 PM			*106	3966*	-		RUS			Page 1
Item ID: Revision ID: Item Name:	D4005-5 Angle			Acce	pt	*N900	040	100) *	Setup Sta	I	S1* S2*
Start Date: Required Date: Reference:	9/11/2013 9/16/2013	Start Qty: 8.0 Req'd Qty: 8.0		8* 8*		Cust Item :	ID:					
Approvals:		an: MF	Date: \3 Date:		oling:		ate:]		op	R1* R2*
Sequence ID/ Work Center II	0	Operation Description			Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Rev	vision Nbr						-				
D4005	В											
*100 *100*				. 0	.00				8	٥		Jm13-09-16
Waterjet FLOW CNC Waterje 2024 - 040		Memo 1-Cut : Dwg R Prog R	as per Dwg ev:	(0.00							OMIS-G 4
		2-Debi	ırr if necessary				!					
*110 *110*		QC2- Inspect parts	off machine FAI/FAIB	0	.00		•		8	_		<i>a</i>
QC		Memo		0	.00					٥		Jm 13-09-16

Memo

Quality Control

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·	DQA:	Date:	•
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NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

										QA Closed:	Da	te:	·
Work Orde	rr:				DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part N	lo				Rework Scrap Use-as-is Work Order Update] 	N herm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier		Engineering Quality Other
Root				Descri	ption of work order update	Initi	ial	Act	tion	Sign &			
Cause	Date	Step	Qty		or Non-conformance	Chief	Eng	Desci	ription	Date	Verificatio	n	QC Inspector
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	_	I/Crimped		L	Burrs	—		ions Incomplete/	Unclear	Part Lost/Mi	issing	wı	rong Stock Pulled
	Cuffs			<u> </u>	Contamination	\vdash		nance		Part Moved			
	Heat Tro				Countersink	-	slabe		<u> </u>	Positioned V	<u> </u>		•
		on Strip in	Tube	<u> </u>	Cut Too Short	\vdash	sread	i	L	Power Loss/	Surge	Ot	her
	Ripples				Drill Holes	\vdash	fset						
		Waves in I		n L	Drawing			Calibration					
	Turning Sequence Finish					Out of Sequence							
	MA/ava/T	wict in Tu	ho		Folio	I lou	itcida	Dimensions					

Work Ord Wednesday, Sep		6966 013 2:00:39 PM	·	*106	966*				.			Page 2
Item ID: Revision ID: Item Name:	D4005-5 Angle			Accept	*N900	040	100) *	Setup	Start Stop	1/1	S1* S2*
Start Date: Required Date Reference:	9/11/2013 : 9/16/2013	Start Qty: 8.00 Req'd Qty: 8.00	*8* *8*		Cust Item :	ID:						
Approvals:	Process Pla	an:	Date:	Tooling:	D	ate:			Run	Start	I <i>Л</i>	R1*
	QC:		Date:	SPC (Y/N):	D	ate:				Stop	*N	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours DAS	Tool ID	Tool #	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
*120 *120* oc		QC8- Inspect parts - seco	ond check	^{0.00} 27 9-89				8				
Quality Control		Memo		0.00 139 16	•							
130		Bend as per dwg		0.00				0				Sh
130 Brake NC Brake NC		Memo		0.00				-8				<u> </u>
140		QC5- Inspect part comple	eteness to step on W/O	DAS 0.00 27								
*14 ∩ *		Memo		9-89	P			8				

Quality Control

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-C	CONF	ORI	MANCE / UPD	ATE			
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Work Orde	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part N	- . No.					Rework Scrap Use-as-is		i Thern	Skid-tube Machining noforming	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR I	V O				 	Work Order Update	ا ا		Large Fab	Composite	J	Supplier	
Root					Descri	ption of work order update	Ini	tial	Actio	on	Sign &		
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	\Box	Bending		,		Bend	∐G	rain			Ovalized		Pressure/Forced
ļ		Centre No	ot Concer	ntric to	o/s	BOM/Route	I IH	ardwa	re		Over/Under	tolerance	Temperature/Cure

Inspection Incomplete

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Instructions Incomplete/Unclear

Weld

Other

Wrong Stock Pulled

Part Incorrect
Part Lost/Missing

Part Moved

Positioned Wrong

Power Loss/Surge

Broken/Damaged

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish

Folio

Burrs

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Cracks

Cuffs

Heat Treat

Crushed/Crimped

Inspection Strip in Tube

Torque Waves in Extrusion

Work Ordo Wednesday, Sep		6966 013 2:00:39 PM		*10	6966*							Page 3
Item ID: Revision ID: Item Name: Start Date:	D4005-5 Angle 9/11/2013	Start Qty: 8.00	*8*	Accept	*N900		100)*	Setup	Start Stop		S1* S2*
Required Date: Reference:	9/16/2013	Req'd Qty: 8.00	*8*		Customer:		_		Run	Start		- 4 di
Approvals:		nn:	Date:	Tooling: SPC (Y/N):		ate:			Kun	Stop	*N *N	R1* R2*
Sequence ID/ Work Center II 150 *150* HandFinish Hand Finishing)	Operation Description Chemical Conversion Co	oat per QSI005 4.1	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Re Qt		Reject Number	Insp. Stamp <i>rd[n] 13-</i> 09-16
*160 *160* QC Quality Control		QC7-Inspect Chemical C	onversion Coat	0.00 27 9-89 0.00 / 3 -	9-16			8				
170 *170* Packaging Packaging		Identify as per dwg & Sto	ock Location D	0.00				_\$x	<u> </u>			SJ 3-9-16.

		DQA:	Date:	•
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recit.		, 110				WOM ONDER HOM			virtitely of		QA Closed:	Date	e:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS		
Part I	No.			V 7 1 12		Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other	
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Root					b .	ption of work order update		Initial		tion	Sign &			
Cause	_	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector	_
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		Bending				Bend		Grain			Ovalized	Γ	Pressure/Forced	
	Г	Centre No	ot Concei	ntric to	o/s \vdash	BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure	
		Cracks			·	Broken/Damaged		4	ion Incomplete		Part Incorre	—	Weld	
	Г	Crushed/	Crimped) 	Burrs		4	ions Incomplete/	Unclear	Part Lost/Mi	issing	Wrong Stock Pulled	
	Г	Cuffs				Contamination		Mainte			Part Moved			
		Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other	
		Ripples in	n Bend			Drill Holes		Offset						
		Torque W	Vaves in E	xtrusio	n 🗀	Drawing		Out of 0	Calibration					
	F-1					Finish		Out of	Sequence					

Outside Dimensions

Wave/Twist in Tube

Folio

Work Order ID 106966 *106966* Page 4 Wednesday, September 11, 2013 2:00:39 PM Item ID: D4005-5 Accept *N900040100* Setup Start **Revision ID:** Item Name: Angle 9/11/2013 Start Qty: 8.00 **Start Date: Cust Item ID:** Req'd Qty: 8.00 **Required Date: 9/16/2013 Customer:** Reference: Start Run Process Plan: Date: Approvals: **Tooling:** Date: Stop Date:_____ QC: SPC (Y/N): Date: Sequence ID/ Operation Set Up/ Reject Tool ID Tool # Plan Accept Reject Insp. **Work Center ID** Description **Run Hours** Code Qty Qty Number Stamp 180 QC21- Final Inspection - Work Order Release 0.00 *180* 0.00 Memo

Quality Control

pl 13-09-14

										DQA:	Date:	•
NCR: Y	es / No				WORK ORDER NON-	COI	NFORM	MANCE / UPD	ATE	QA Closed:	Date:	,
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Work Orde	er:				DISPOSITION				AGAINST DE	PAKTIVIENT, -	/PRUCE35	
Part N	lo				Rework Scrap Use-as-is] -	r	Skid-tube Machining noforming	Crosstube Small Fab Finishing	4	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
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Cause	Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descri	ption	Date	Verification	QC Inspector
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	Cuffs				Contamination		Mainte	nance		Part Moved		_
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<u> </u>	Inspectio	n Strip in	Tube		Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset			-		

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

Page 1

• Wednesday, September 11, 2013 2:00:38 P

Work Order ID:

106966

Parent Item:

D4005-5

Parent Item Name:

Angle

Start Date: 9/11/2013

Required Date: 9/16/2013

Start Qty: 8.00

Required Qty: 8.00

Comments:

IPP rev A 10.02.01 new issue prelim EC verified by:JLM

IPP Rev:B 10.05.03 as per ECN10-

562 DD verified by:EC IPP Rev:C 12 03 07 as per dwg rev h DD verf: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040 2024-T3 .040 sheet		Purchased	No			100	sf	275.4477	1.891	1 5.92 421 ひっるる	SF.		3m 13-09.

Location		Loc Oty	Loc Code	
MAT022		275.4476922		
	120605	65.8254832		
:	121197	57.187894		
1	122136	31.78		
1	123217	20.094315		
1	124987	100.56		124987.

										DQA:	Date	:
NCR: Y	es / No				WORK ORDER NON-C	100	NFORM	MANCE / UP	DATE	QA Closed:	Date	2
					DISPOSITION				AGAINST DE			·
Work Orde	er:					_		_	AGAINST DE		, r MOCESS	· —
Part N	lo				Rework Scrap Use-as-is		ſ	Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	lo				Work Order Update]		Large Fab	Composite		Supplier	
Root				Descri	ption of work order update	Ī	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
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	Inspectio	•	Tube	<u> </u>	Cut Too Short		Misread			Power Loss/	Surge	Other
	Ripples in	n Bend			Drill Holes		Offset					
	Torque V	Vaves in E	Extrusio	n [Drawing		Out of 0	Calibration				

Out of Sequence

Outside Dimensions

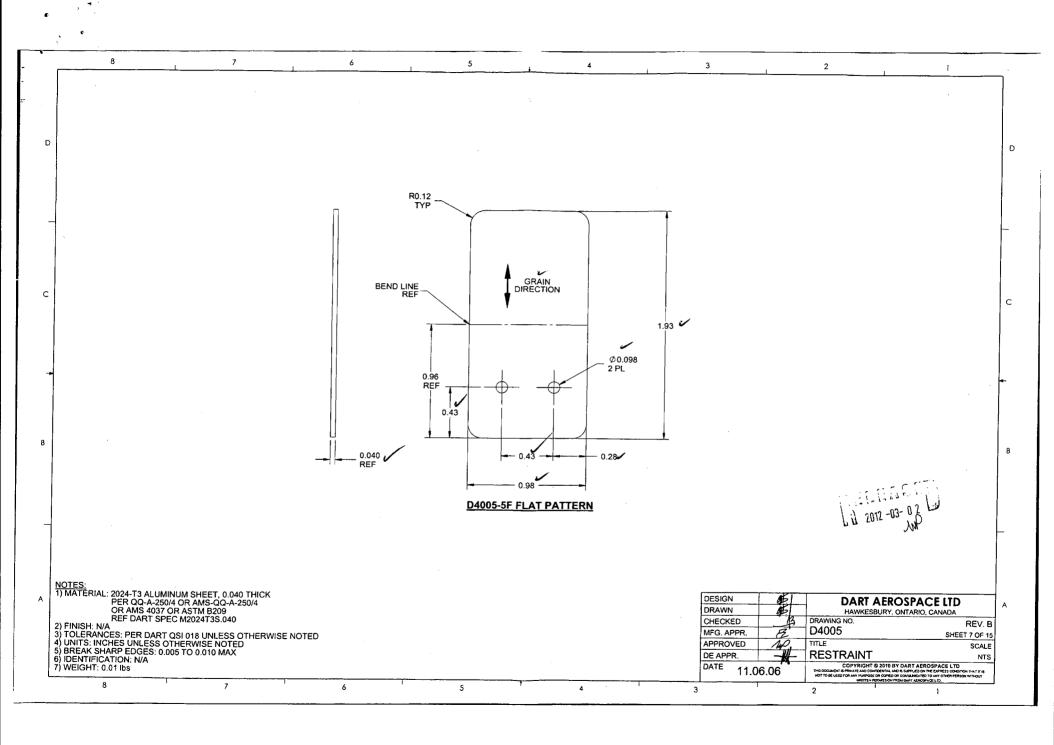
Turning Sequence

Wave/Twist in Tube

Finish

Folio

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										DQA:	Date	: `	
NCR: Y	es / No				WORK ORDER NON-O	COI	NFORM	MANCE / UPI	DATE			• • •	
					·					QA Closed:	Date	:	
Work Order:					DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part N	lo				Rework Skid-tube Crosstube Machining Small Fab Use-as-is Work Order Update Large Fab Composite			4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other			
Root				Descri	ption of work order update		Initial	Act	tion	Sign &	·-		
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	Centre N	lot Conce	ntric to (o/s	BOM/Route		Hardware			Over/Under	tolerance	Temperature/Cure	
	Cracks				Broken/Damaged		Inspection Incomplete			Part Incorred	ct	Weld	
	Crushed	/Crimped			Burrs		Instructions Incomplete/Unclear			Part Lost/Missing		Wrong Stock Pulled	
	Cuffs				Contamination		Mainte	aintenance		Part Moved			
	Heat Tre	at			Countersink		Mislabe	Mislabeled		Positioned V	Vrong		
	Inspection	on Strip in	Tube		Cut Too Short		Misread	İ		Power Loss/	Surge	Other	
	Ripples i	n Bend			Drill Holes		Offset						

Out of Calibration
Out of Sequence

Outside Dimensions

Turning Sequence

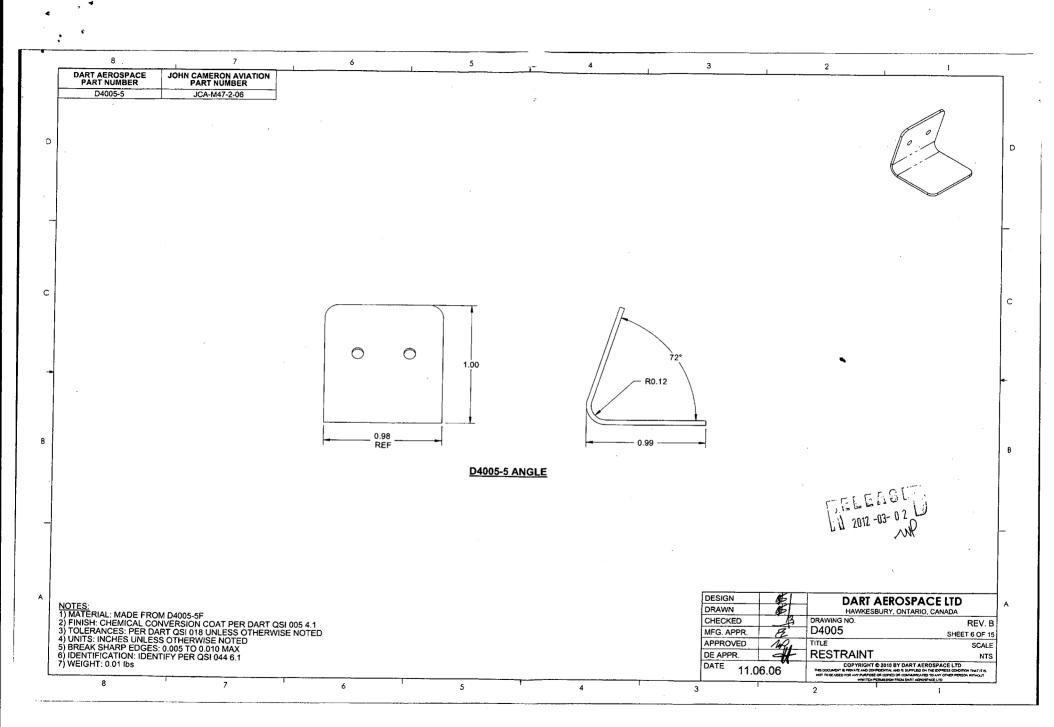
Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish Folio

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										DQA:	Date:	· -
NCR: Yes	/ No				WORK ORDER NON-O	COI	NFOR	MANCE / UPI	DATE	QA Closed:	Date:	*
Work Order: Part No.					DISPOSITION Rework Scrap		1	Skid-tube Machining	AGAINST DE Crosstube Small Fab	Pro	Water Jet od. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Work Order Update		Thern	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	iption of work order update	T	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty	1	or Non-conformance	Ch	nief Eng	Desci	ription	Date	Verification	QC Inspector
Doc/Data					11.00							
Equip/Tooling												
Operator												
Material					•					1		

Unapproved **FAULT CATEGORY Landing Gear** General Pressure/Forced Bend Ovalized Bending Grain Hardware Over/Under tolerance Temperature/Cure BOM/Route Centre Not Concentric to O/S Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Wrong Stock Pulled Crushed/Crimped Instructions Incomplete/Unclear Part Lost/Missing Burrs Cuffs Part Moved Contamination Maintenance Positioned Wrong Mislabeled Heat Treat Countersink Other Cut Too Short Power Loss/Surge Inspection Strip in Tube Misread Drill Holes Ripples in Bend Offset Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Outside Dimensions Folio Wave/Twist in Tube

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Setup
Other
Process
Supplier
Training

DART AEROSPACE LTD	Work Order: 106966
Description: Angle	Part Number: 04005-5
Inspection Dwg: 04005 Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing	Tolerance	Actual	Accept	Reject	Method of		
Dimension	rolerance	Dimension	Accept	Reject	Inspection	Comments	
Ø 0.098°	40.004-0.001	0.098"			U	JLMOI	
1.93"	tho:030°	1.931"	-		V		
0.98"	(I	0.990	\		υ		
0.43"	t 1	0.435"	_		>		
0.58,	М	04350	980° -		ν		
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0.040"	4-0,010"	0.040			V		
Grain Di	retion	N/A.	ا				
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	,			. :		***************************************	
			DAS 27				

Measured by:	Audited by:	Preliminary Approval:
Date: 13-09-16	Date: 15 9 16	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

A 10.04.15